Work Order ID 116851

116851

April-24-14 8:07:40 AM

Item ID:	D3572-041	Accept	***N9000401100***
Revision ID:			
Item Name:	Guide		

Setup Start *NS1*
Stop *NS2*

Start Date:	4/23/14	**Start Qty:** 1.00	***1***	**Cust Item ID:**
Required Date:	4/23/14	**Req'd Qty:** 1.00	***1***	**Customer:**

Reference:

Run Start *NR1*
Stop *NR2*

Approvals: Process Plan: MLJ   Date: 14-04-25   Tooling: _____   Date: _____
QC: _____   Date: _____   SPC (Y/N): _____   Date: _____

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	Draw Nbr	**Revision Nbr**								
	D3572	Rev D ✓								
100 ***100*** Packaging	Pick Kit		0.00							FF 14-07-14
Packaging		**Memo**	0.00						1	
110 ***110*** Small Fab	Small Fab		0.00							FF 14-07-14
Small Fab		**Memo** 1-Cut Tube D3572-1 as per Dwg D3572 2-deburr both ends	0.00						1	
120 ***120*** QC	QC5- Inspect part completeness to step on W/O		0.00						1	DAS 27 9-89 14-7-14
Quality Control		**Memo**	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

⌐DART AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

<table>
<tr><td colspan="2" rowspan="4">Work Order: _____

Part No. _____

NCR No. _____</td><td colspan="2">DISPOSITION</td><td colspan="6">AGAINST DEPARTMENT/PROCESS</td></tr>
<tr><td>Rework ☐</td><td></td><td>Skid-tube ☐</td><td>Crosstube ☐</td><td>Water Jet ☐</td><td>Engineering ☐</td></tr>
<tr><td>Scrap ☐</td><td></td><td>Machining ☐</td><td>Small Fab ☐</td><td>Prod. Eng. Coor. ☐</td><td>Quality ☐</td></tr>
<tr><td>Use-as-is ☐</td><td></td><td>Thermoforming ☐</td><td>Finishing ☐</td><td>Rec/Store/Packaging ☐</td><td>Other ☐</td></tr>
<tr><td></td><td>Suspected Unapproved ☐</td><td></td><td>Large Fab ☐</td><td>Composite ☐</td><td>Supplier ☐</td><td></td></tr>
</table>

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function

- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence

- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____
_____

116851

Item ID:	D3572-041
Revision ID:	
Item Name:	Guide
Start Date:	4/23/14
Required Date:	4/23/14

Start Qty: 1.00   ***1***
Req'd Qty: 1.00   ***1***

Accept   ***N9000401000***

Cust Item ID:
Customer:

Setup Start ***NS1***
Stop ***NS2***

Reference:

Run Start ***NR1***
Stop ***NR2***

Approvals: Process Plan: _____ **Date:** _____ Tooling: _____ **Date:** _____

QC: _____ **Date:** _____ SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 ***130*** Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: M129377 Large Fab	0.00 0.00				1	A	/4·10·28	
	Memo 1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572 2- grind weld flush at the end of tube only								
140 ***140*** QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00				Cpl	1	14.10.29	
	Memo	0.00							
150 ***150*** QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				Cpl	1	14.10.29	
	Memo	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION
- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS
- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear
- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function

- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence

- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____
_____

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID   116851

116851

April-24-14 8:07:40 AM

Item ID:	D3572-041	Accept
Revision ID:		
Item Name:	Guide	

N9000401OO

Setup	Start	***NS1***
	Stop	***NS2***

Start Date:	4/23/14	**Start Qty:** 1.00	***1***
Required Date:	4/23/14	**Req'd Qty:** 1.00	***1***

Cust Item ID:	
Customer:	

Reference:

Run	Start	***NR1***
	Stop	***NR2***

Approvals:	**Process Plan:** _____	**Date:** _____	**Tooling:** _____	**Date:** _____
	QC: _____	**Date:** _____	**SPC (Y/N):** _____	**Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 ***18O*** HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1 ʌ	d	ℓℓℓ	cu 10/25
190 ***19O*** Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 128564. Memo START TIME: 220 OVEN TEMPERATURE: 320° FINISH TIME: 3:00	0.00 0.00				1	0	14-10-29	DAS 34 9-89
200 ***2OO*** QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			DAS 38 9-89 OCT 3 0 2014

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____	Part No. _____	NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

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☐ Hardware
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☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Work Order ID 116851

April-24-14 8:07:40 AM

116851

Item ID:	D3572-041	Accept
Revision ID:		
Item Name:	Guide	

N9000040100

Setup	Start	***NS1***
	Stop	***NS2***

Start Date:	4/23/14	**Start Qty:** 1.00	***1***
Required Date: 4/23/14		**Req'd Qty:** 1.00	***1***

Cust Item ID:

Customer:

Reference:

Run	Start	***NR1***
	Stop	***NR2***

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 ***210*** Packaging Packaging	Identify as per dwg & Stock Location: ST255	0.00				①			
	Memo	0.00							
220 ***220*** QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

DAS
46
9-89

OCT 3 0 2014

14/11/3

~~Ru-10:30~~

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____					**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**				

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION
- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS
- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

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- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____
_____

Picklist Print

April-24-14 8:07:46 AM

Work Order ID: 116851

Parent Item: D3572-041

Parent Item Name: Guide

116851
D3572-041

Start Date: 4/23/14 **Required Date:** 4/23/14
Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:A   New Issue 07-02-07   JLM
IPP rev B   revB dwg   EC
IPP Rev:C   Removed D3572-7 Cap 07-06-11   JLM
IPP Rev:D   08-05-27   Review process of IPP   DD   verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			110	f	244.8263	2.34	3			
M6061T6T1 000W 188									**		FF 14-07-14		
6061T6 RD TUBE 1.00 X .188W													

Location	Loc Qty	Loc Code
MAT016	81.7243	
m128248	81.7243	
MAT030	163.102	
117797	19.25	
120935	0.461	
121848	48	
122114	18.121	3
m126686	77.27	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3572-3		Manufactured	No			130	Each	30.0000	4	4			
D3572-3									**		EL 14/0078		
Guide													

Location	Loc Qty	Loc Code
WA002	30	
102360	4	
102786	6	
110689	20	

119368 X 4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

◥◤**DART**
AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____		**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐　Crosstube ☐　Water Jet ☐　Engineering ☐
Machining ☐　Small Fab ☐　Prod. Eng. Coor. ☐　Quality ☐
Thermoforming ☐　Finishing ☐　Rec/Store/Packaging ☐　Other ☐
Large Fab ☐　Composite ☐　Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

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☐ Broken/Damage/Defect
☐ Burrs
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Picklist Print

April-24-14 8:07:46 AM

Work Order ID: 116851

Parent Item: D3572-041

Parent Item Name: Guide

116851
D3572-041

Start Date: 4/23/14   **Required Date:** 4/23/14

Start Qty: 1.00   **Required Qty:** 1.00

D3572-5

D3572-5

Bracket

		Manufactured	No		130	Each	11.0000	1	1

**   *a   /9/0-28*

Location	Loc Qty	Loc Code
WA002	11	
102833	6	/1
89165	5	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

	DISPOSITION	AGAINST DEPARTMENT/PROCESS

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐   Crosstube ☐   Water Jet ☐   Engineering ☐
Machining ☐   Small Fab ☐   Prod. Eng. Coor. ☐   Quality ☐
Thermoforming ☐   Finishing ☐   Rec/Store/Packaging ☐   Other ☐
Large Fab ☐   Composite ☐   Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
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Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear
☐ Bending
☐ Centre Not Concentric
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____